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**Okuma America Corporation**

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**Okuma MTConnect Adapter**

**Release Notes**

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OKUMA MTConnect Adapter	Version: 4.1.3.0
Release Notes	Date: 06/29/2023

## Revision History

<b>Date</b>	<b>Version</b>	<b>Description</b>	<b>Author</b>
7/25/2011	S5053-004-00	Public release System Version 1.0.0.0	Linh Huynh
10/14/2011	S5053-004-01	Public release System Version 1.3.0.0	Linh Huynh
12/20/2011	S5053-004-02	Public release System Version 1.3.2.0	Linh Huynh
02/17/2012	S5053-004-06	Public release System Version 1.3.6.0	Linh Huynh
02/20/2012	S5053-004-07	Public release System Version 1.3.7.0	Linh Huynh
06/08/2012	S5053-004-08	Public release System Version 1.3.8.0	Linh Huynh
10/09/2013	S5053-004-09	Beta release System Version 1.5.0.0	Linh Huynh
11/05/2013	S5053-004-10	Beta release System Version 1.5.1.0	Linh Huynh
01/07/2014	S5053-004-11	Beta release System Version 1.5.2.0	Linh Huynh
01/09/2014	S5053-004-12	Beta release System Version 1.5.3.0	Linh Huynh
04/15/2014	S5053-004-13	Beta release System Version 1.5.4.1	Linh Huynh
05/06/2014	S5053-004-14	Beta release System Version 1.5.5.1	Linh Huynh
05/14/2014	S5053-004-15	Beta release System Version 1.5.5.2	Linh Huynh
05/16/2014	S5053-004-16	Beta release System Version 1.5.5.3	Linh Huynh
06/24/2014	S5053-004-17	Public release System Version 1.5.6.0	Linh Huynh
07/28/2014	S5053-004-18	Beta release System Version 1.5.6.1	Linh Huynh
08/04/2014	S5053-004-19	Public release System Version 1.5.7.0	Linh Huynh
10/31/2014	S5053-004-20	Public release System Version 2.0.0.0	Linh Huynh
02/06/2015	S5053-004-21	Public release System Version 2.1.0.0	Linh Huynh
06/19/2015	S5053-004-22	Beta release System Version 2.1.2.0	Linh Huynh
09/24/2015	S5053-004-23	Beta release System Version 2.2.2.0	Linh Huynh
06/24/2016	S5053-004-25	Public Release System Version 2.2.5.0	Linh Huynh
09/26/2016	S5053-004-26	Public Release System Version 3.0.0.0	Linh Huynh
03/16/2017	S5053-004-27	Public Release System Version 3.1.0.0	Linh Huynh
04/11/2019	S5053-004-28	BETA Release System Version 3.1.9.0	Linh Huynh
11/05//2019	S5053-004-29	Public Release System Version 3.2.0.0	Linh Huynh
02/19/2020	S5053-004-30	Public Release System Version 3.2.1.0	Linh Huynh
03/19/2021	S5053-004-31	Public Release System Version 3.3.0.0	Linh Huynh
05/04/2021	S5053-004-32	Public Release System Version 3.3.1.0	Linh Huynh
12/14/2021	S5053-004-33	Public Release System Version 3.3.2.0	Linh Huynh
05/09/2022	S5053-004-34	Public Release System Version 4.0.0.0	Linh Huynh

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05/09/2022	S5053-004-35	Public Release System Version 4.1.0.0	Linh Huynh
02/20/2023	S5053-004-36	Public Release System Version 4.1.1.0	Linh Huynh
04/11/2023	S5053-004-37	Public Release System Version 4.1.2.0	Linh Huynh
06/29/2023	S5053-004-37-01	Public Release System Version 4.1.3.0	Linh Huynh

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# Release Notes for Okuma MTConnect Adapter

## 1. Introduction

### 1.1 Disclaimer of Warranty

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### 1.2 Purpose

The purpose of the **Release Notes** document is to communicate major new features and changes in this release of the Okuma MTConnect Adapter. It also documents known problems and workarounds.

### 1.3 Scope

This document describes this public release of Okuma MTConnect Adapter version 4.1.3.0

### 1.4 References

None

## 2. About This Release

In this release, the device configuration file, named Devices.xml, is automatically generated by the application to meet per machine specification that the adapter currently can support.

### 2.1 Prerequisite Software

This release of this application is required to include:

- THINC API release 1.22.5.0 for Lathe
- THINC API release 1.22.5.0 for MC
- THINC API release 1.22.5.0 for Grinder
- Start-up Service version 4.4.0 or latest version
- MTConnect Agent version 1.6.0.7 or latest version

### 2.2 License

Not applicable

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## 2.3 Machine Model

This release supports OKUMA OSP- P300A/P300/P200/P100II or newer controls.

The following files included with the installation disk contain data items that can be supported per machine type:

- Lathe2SPDevices.xml : Lathe with 2 sides
- LatheDevices.xml: Any Lathe except for 2 sides Lathe
- MCDevices: Any Machining Center
- GrinderDevices: Any P300G Grinder
- Agent.cfg: default agent configuration file

Please contact your local distributor service department if you experience any difficulties with installing the software or using the system.

## 2.4 Features

The adapter supports MTConnect schema version 1.2.0 to 1.4.0 only.

This version and new version of MTConnect Adapter can support the following languages:

- English (default)

## 3. Changes/New

### 3.1 System Configuration

Please refer to the section 5.3.2.1.3 MTConnect Tags Settings in the Installation Manual for more information

## 4. Known Issues

### 4.1.1 P100II - Two side Lathe

```
<DataItem type="EXECUTION" name="p1execution" category="EVENT" id="L2p1execution"/>
<DataItem type="EXECUTION" name="p2execution" category="EVENT" id="L2p2execution"/>
```

Feed hold status does not report correctly for these tags. It only reports the current active side of machine on NC HMI but not the individual side of machine.

### 4.1.2 P300G

```
<DataItem type="PROGRAM" name="p1program" category="EVENT" id="Gp1program"/>
<DataItem type="PART_COUNT" name="p1partcount" category="EVENT" id="Gp1partcount"/>
```


When Grinder uses Work Selection, part count and part program can only report total count of program for Grinding G Cycle as a whole.

The future release of OSP system will allow part program and part count per running part program when Work Selection is using.

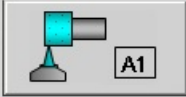
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**CYCLE SELECT**

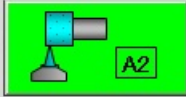
SELECT INDEX PROGRAM



G



A1



A2

CYCLE	SELECT MAIN PROGRAM	PROGRAM NAME
GRINDING G	LD-GRIND.MIN	02345
DRESSING A1	LD-DRESS.MIN	01234
WHL. TRUING A2	LD-IDRS.MIN	04567

AUTO OPERATION		W0001.IDX							
MacMan HMI									
START	OPERATING	IN-PRO SETUP							
MACH NAME:MC.NAME									
MACHINING REPORT:DAILY(TODAY):2016/09/16									
MAIN PROGRAM	PROG NAME	START DAY	START TIME	NO.OF WORK	OPERATING %	RUNNING	OPERATING	CUTTING	
LD-GRIND.MIN	04567	2016/09/16	00:00:00	7	0	16:15	0	0	
SUM		2016/09/16	00:00:00	7	0	16:15	0	0	

#### 4.1.3 Tool Data for P300S/P300L

For P300S(LP) :

Tool Asset, Current Tool for A/B/C turret, and ToolAssetID tags will not be available when one of the following conditions are met:

- Tool ID is ON
- TMIM is OFF

For P300L:

Tool Asset, Current Tool for A/B/C turret, and ToolAssetID tags will not be available when the specification of LTIM is OFF.

```

<!-- Tool Path related to upper A/H1 turret-->
<DataItem type="TOOL_NUMBER" name="p1CurrentTool" category="EVENT" id="Lp1CurrentTool" />
<DataItem type="TOOL_ASSET_ID" name="p1ToolAssetId" category="EVENT" id="Lp1ToolAssetId" />

<!-- Tool Path related to B turret-->
<DataItem type="TOOL_NUMBER" name="p2CurrentTool" category="EVENT" id="Lp2CurrentTool" />
<DataItem type="TOOL_ASSET_ID" name="p2ToolAssetId" category="EVENT" id="Lp2ToolAssetId" />

<!-- Tool Path related to C turret-->
<DataItem type="TOOL_NUMBER" name="p3CurrentTool" category="EVENT" id="Lp3CurrentTool" />
<DataItem type="TOOL_ASSET_ID" name="p3ToolAssetId" category="EVENT" id="Lp3ToolAssetId" />

<?xml version="1.0" encoding="UTF-8"?>
<MTConnectAssets xsi:schemaLocation="urn:okuma.com:OkumaToolAssets:1.3/schemas/OkumaToolAssets_1.3.xsd"
xmlns:x="urn:okuma.com:OkumaToolAssets:1.3" xmlns:xsi="http://www.w3.org/2001/XMLSchema-instance"
xmlns="urn:mtconnect.org:MTConnectAssets:1.3" xmlns:m="urn:mtconnect.org:MTConnectAssets:1.3"><Header

```

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assetCount="0" assetBufferSize="1024" version="1.3.0.17" instanceId="1484830744" sender="OKUMA-90BF578E1" creationTime="2017-01-19T13:00:10Z"/><Assets/></MTConnectAssets>

## 5. Defects fixed in this release

### 5.1 MacMan Data corrupted

Preventing the lock-up scenario on MacMan data when the communication of MTConnect Agent with MTConnect Adapter is disrupted by external sources such as network port conflict, security, etc.

### 5.2 System Configuration Setting

Using Execution information in System Configuration is not saved after restarting the application.

### 5.3 Operation and Execution Tag Error on P100/P200

Fixed issue on Lathe machine with OSP-100II and OSP-200 controls.  
Exception occurs in these tags when running on P100/P200 Lathe controller.